

Work Order ID 65016

Wednesday, January 05, 2011 1:42:18 PM



Page 1

Item ID:	D3236-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Window					
Start Date:	1/5/2011	Start Qty: 5.00		Cust Item ID:		
Required Date:	1/14/2011	Req'd Qty: 5.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>1/01-5</u>	Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3236	Rev B								

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

Cut as per Dwg D3236 ☐ Dwg Rev: B ☐ Prog Rev: B

0.00

0.00

B11-1-5

(5)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B11-1-5

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

8110105

(5)

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Item ID: D3236-1

Accept

Revision ID:

Item Name: Window

Start Date: 1/5/2011 Start Qty: 5.00

Required Date: 1/14/2011 Req'd Qty: 5.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
	Memo	0.00							
	Deburr <input type="checkbox"/> Engrave Part Number & Batch Number as per Dwg D3236								
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								
150  Packaging	Identify as per dwg & Stock Location <u>217</u>	0.00							
	Memo	0.00							
	Packaging								

E 5/11/01/06 (5)

(5)

1/11/10 SP (5)

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Item ID: D3236-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 1/5/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/01/10
MF

11-01-6

Picklist Print

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Page 1

Work Order ID: 65016

Parent Item: D3236-1

Parent Item Name: Window



Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev. A 06.03.07 New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.125

Purchased

No

110

sf

201.3222

1.955

10.28947

10.4



1131-1-5

1/8" Polycast II Sheet

Location

Loc Qty

Loc Code

MAT

201.3222

113204

4

113861

10.4

114673

9.6722

115338

177.25

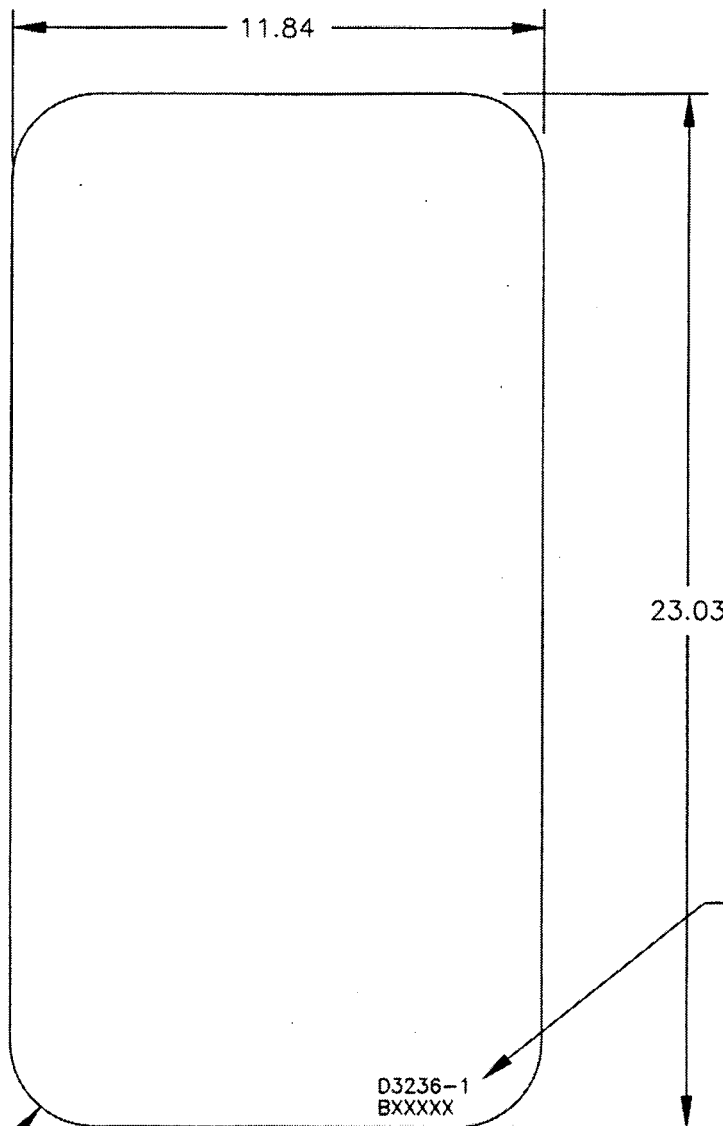
113861

5



DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D3236	REV. B SHEET 1 OF 1
DATE 04.05.05				TITLE WINDOW	SCALE NTS
A	03.12.18			NEW ISSUE	
B	04.05.05			ADD THICKNESS & ENGRAVING SPEC	

RELEASED
04.05.12 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *65016*

PS 11-01-6

ENGRAVE P/N D3236-1 AND
B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO
MAXIMUM DEPTH OF 0.005"

R1.90
(TYP)

D3236-1
BXXXXX

D3236-1 WINDOW

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 0.125" THICK
(REF DART SPEC. M-ACRYLIC-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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